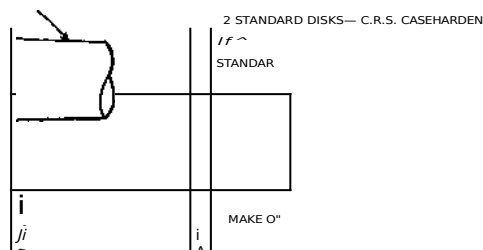


when cutting to length or milling clearance cuts. The jaws here shown are used for cutting off pieces from a bar of stock, which is pushed up against the stop and then cut off to the desired length.

Fixture for Milling to Given Length. — When accuracy in length is essential, a fixture like the one shown in Fig. 2 can be used to advantage. The part to be machined is cut to the approximate length in vise jaws or with a power hacksaw and then straddle-milled in the fixture. Here it is located between the two pawls *B* and clamped in place by the strap and cam. On the arbor shown in Fig. 3 are mounted two steel disks *A* about 1/2 inch larger in diameter than the two side milling cutters.



*Macji
nery*

Fig. 3. Arrangement of Cutters used with Fixture shown in Fig. 2

When the fixture is fed underneath the arbor, these disks depress the pawls and give clear passage for the cutters. On the same arbor can be mounted other cutters to suit the work. This arbor should never be taken down, as it is important that the distance between the straddle-mills be kept constant; the cutters should be ground on the arbor.

Duplex Fixture. — The milling fixture shown in Fig. 4 is made

for machining two parts in one operation. On the cast-iron base is mounted a double seat block and the seats are ground after assembling. The parts to be milled are clamped in place by cam binders at each end and two straps. By using set-screws in the straps, accuracy in making the cams is not necessary, and wear on the cam faces can be taken up by these adjusting screws.